

Date: Thursday, 02/04/2009 2:25:11 PM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: FRAME		
Job Number	46832			Part Number	: D23301		
Estimate Number	13818			Drawing Number	: D2330 REV G		
P.O. Number	:			Project Number	: N/A		
This Issue	02/04/2009 S.O. No. :			Drawing Revision	: G		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 14/04/2009 Qty: 4 Um: Each		
Previous Run	:						
Written By	:						
Checked & Approved By	: <u>JUL 09-04-02</u>						
Comment	: Est Rev:A 09.03.18 New Issue EC verified by:DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
		Comment: Qty.: 7.3710 f(s)/Unit Total : 29.4840 f(s) 304 SQ Tube .75x.75x.065W batch: <u>m111148</u>	
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 1- Cut as per dwg D2330 2- Deburr and remove identification markings on tube	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ICS</u>	
5.0	QC21	FINAL INSPECTION/W/O RELEASE	
		Comment: FINAL INSPECTION/W/O RELEASE	
	Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

G

RELEASED
[Signature]

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.2.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

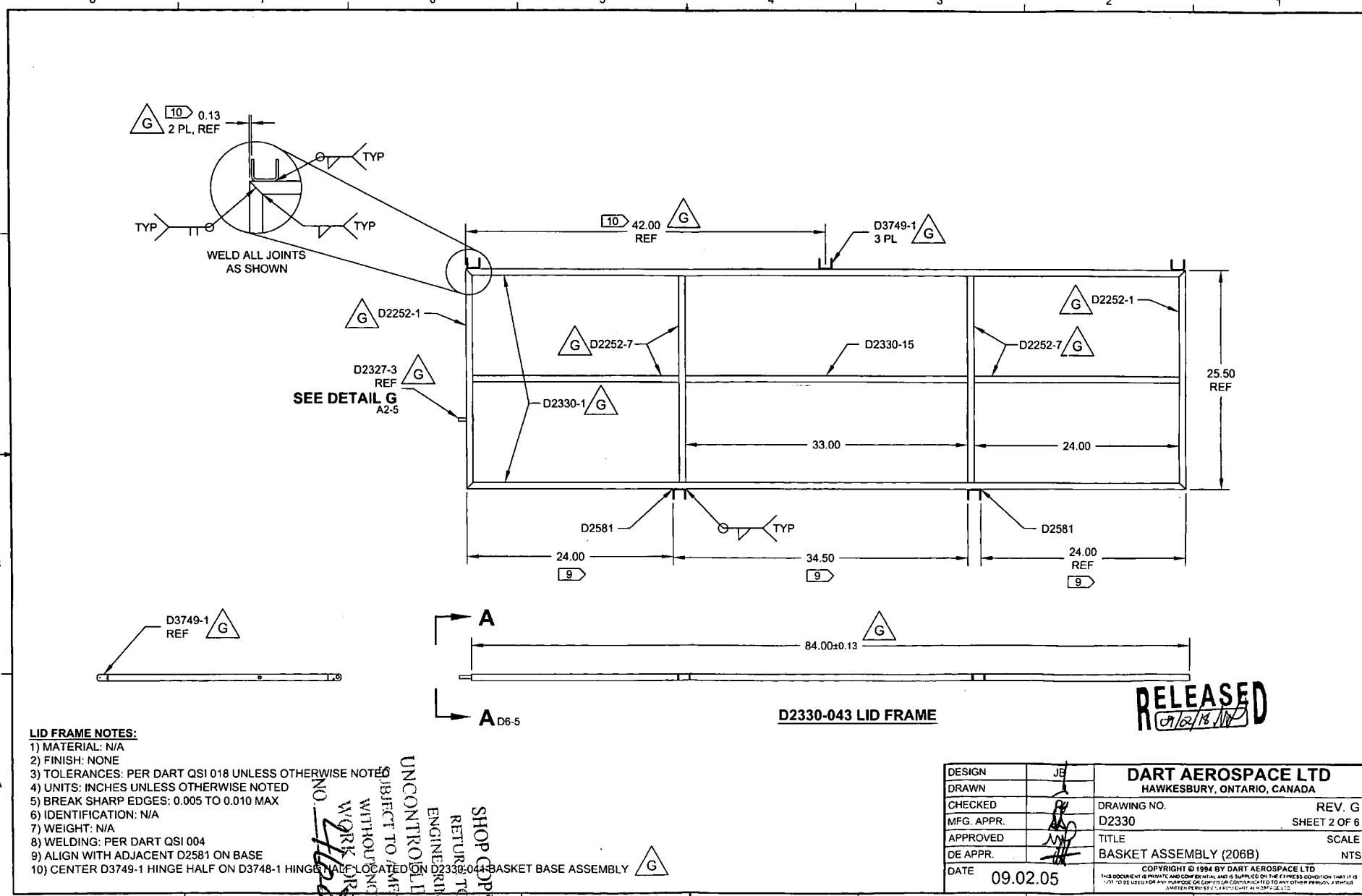
110832

A B C D

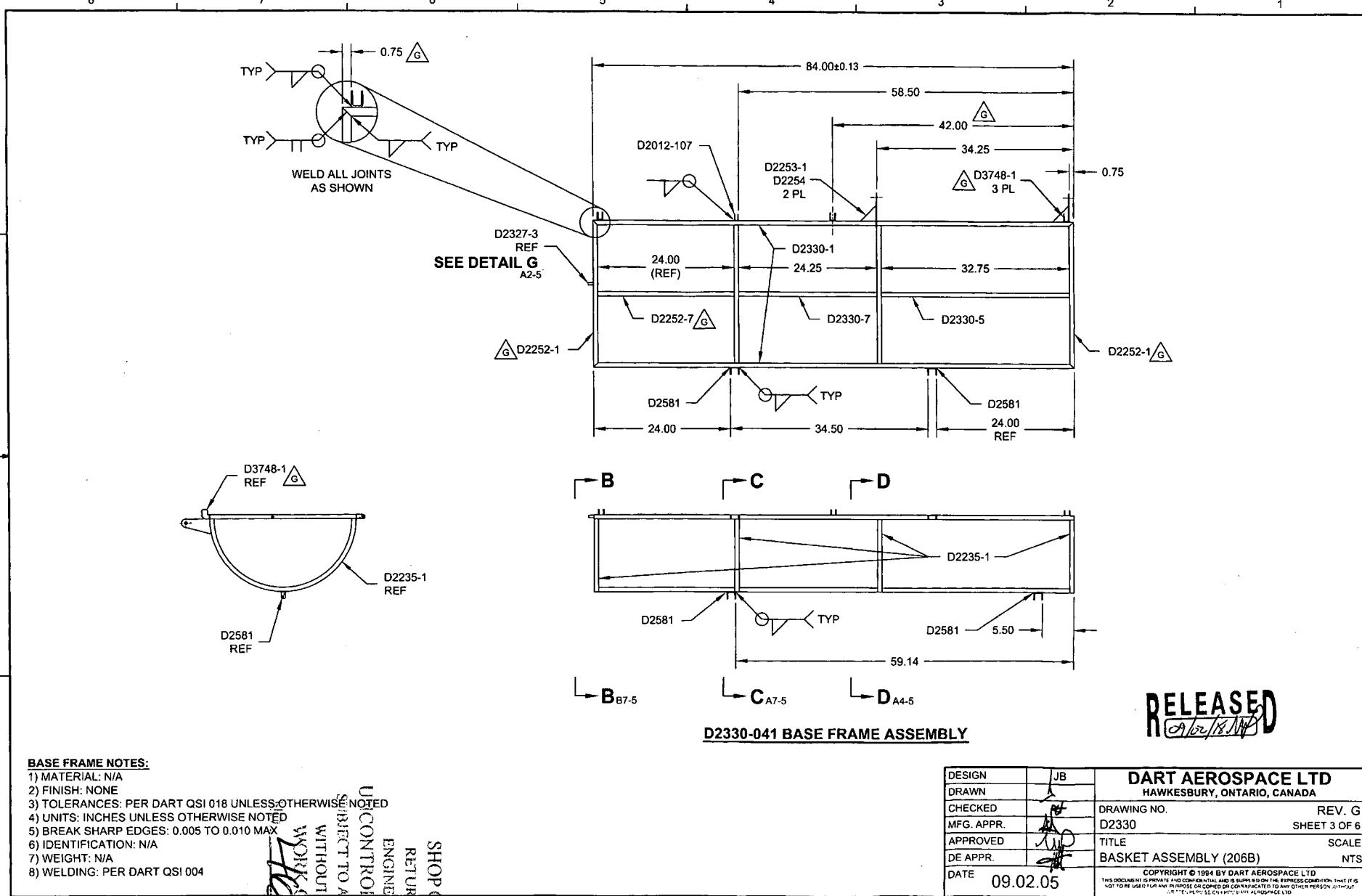
8 7 6 5 4 3 2 1

SHOP COPY RETURN TO
ENGINEERING SUBJECT TO AMENDMENT
UNCONTROLLED COPY WITHOUT NOTICE

REV.	DESCRIPTION	BY	DATE
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DESIGN	JB	DRAWING NO. REV. G	
DRAWN	>	D2330 SHEET 1 OF 6	
CHECKED	<	MFG. APPR. AJS	
MFG. APPR.	AJS	TITLE SCALE	
APPROVED	MW	BASKET ASSEMBLY (206B) NTS	
DATE	09.02.05	COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, EXCEPT AS COMMUNICATED TO ANY OTHER PERSON WITHIN THE DART AEROSPACE LTD. ORGANIZATION.	

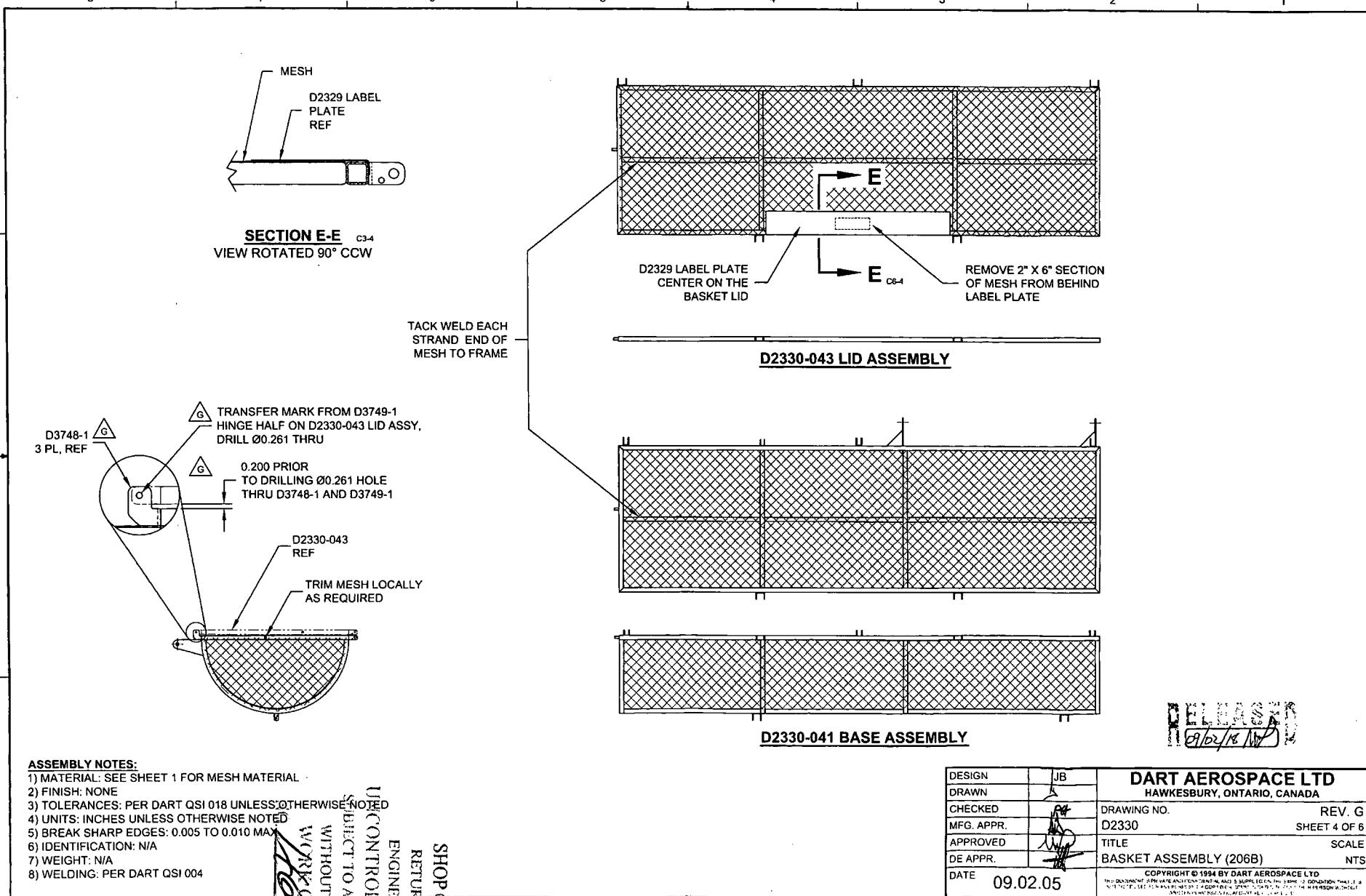


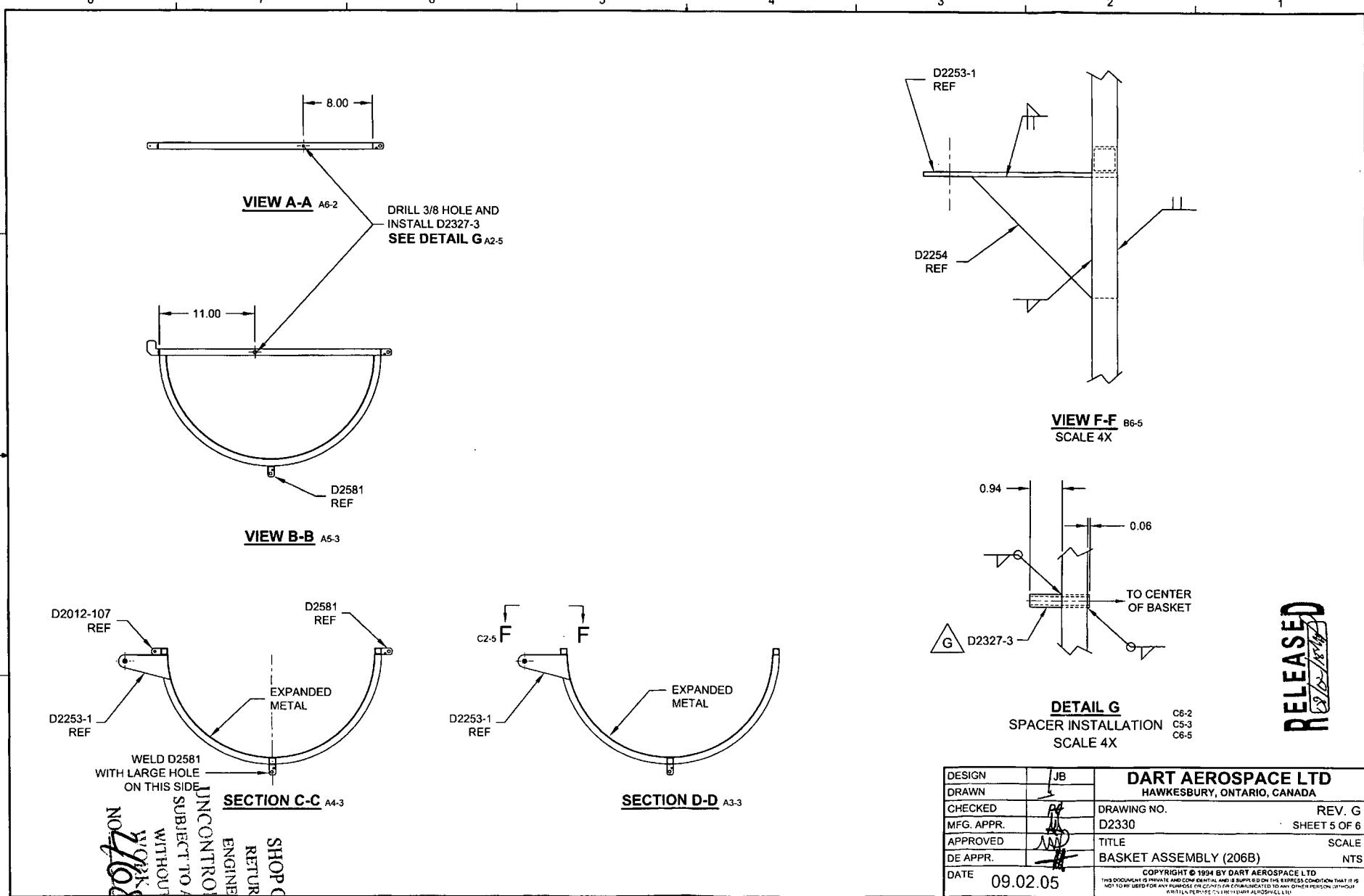
DESIGN	JE	DART AEROSPACE LTD
DRAWN	1	HAWKESBURY, ONTARIO, CANADA
CHECKED	2	DRAWING NO. REV. G
MFG. APPR.	3	D2330 SHEET 2 OF 6
APPROVED	4	TITLE SCALE
DE APPR.	5	BASKET ASSEMBLY (206B) NTS
DATE	09.02.05	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD AND IS TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON, WITHOUT PERMISSION, EXCEPT AS AUTHORIZED IN DART AEROSPACE LTD'S AGREEMENTS.



DESIGN DRAWN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. G
APPROVED		SHEET 3 OF 6
DE APPR.		TITLE
DATE		SCALE
09.02.05		NTS

COPYRIGHT © 1994 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 THE EXPRESSED WRITTEN CONSENT OF DART AEROSPACE LTD





NO 46832
WORK ORDER
ENGINEERING
RETURN TO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D2330
CHECKED	P4	REV. G SHEET 5 OF 6
MFG. APPR.	AP	TITLE BASKET ASSEMBLY (206B)
APPROVED	AND	SCALE NTS
DE APPR.		
DATE	09.02.05	COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS FOR INTERNAL USE ONLY AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED

8 7 6 5 4 3 2 1

D

D

C

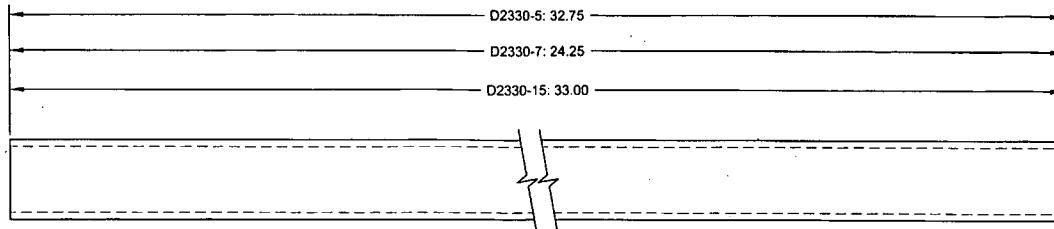
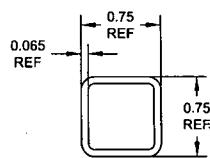
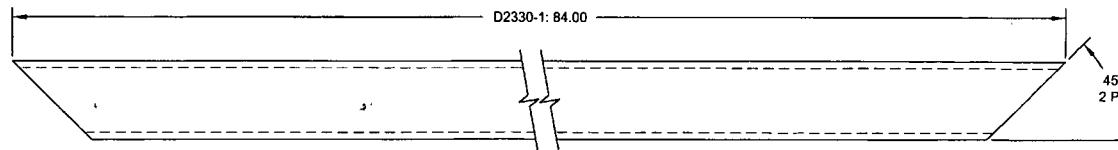
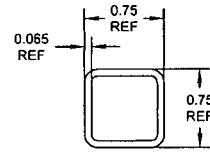
C

B

B

A

A

D2330-5 FRAMED2330-7 FRAMED2330-15 FRAMED2330-1 FRAME

RELEASED
09/02/18

- NOTES:**
- 1) FRAME MATERIAL: SEE SHEET 1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

H683
 ENGINEERING
 CENTER
 SUBMITTER
 TO AMENDMENT
 NOTICE
 CEDER
 ENGINEERING
 CONTROLLED COPY
 SHOP COPY
 RETURN TO
 ENGINEER

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. G	
APPROVED		D2330	
DE APPR.		SHEET 6 OF 6	
DATE	09.02.05	TITLE	SCALE
		BASKET ASSEMBLY (206B)	
		NTS	

COPYRIGHT © 1994 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED OR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 THE EXPRESS WRITTEN APPROVAL OF DART AEROSPACE LTD

8 6 5 4 3 2 1